

Work Order ID 125664

October-20-14 8:01:44 AM

125664

Page 1

Item ID: D2362-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Step Support Bracket

Start Date: 10/20/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/24/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2362

Rev E1

100

0.00

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA800 Rev: 44 & Dwg D2362 Rev: E1 2-Deburr
per dwg D2362

cm 14/10/26 10 0

110

QC2- Inspect parts off machine FA1/FA1B

0.00

110

QC

Memo

0.00

Quality Control

cm 14/10/26 10 0

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10 SL 14/10-27

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Item ID: D2362-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Support Bracket
 Start Date: 10/20/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/24/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

130

Small Fab

Small Fab

Small Fab

Memo
Reburr

PLA done in making

0.00

0.00

0.00

140

140

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M 129808

Memo

START TIME:

8:15

OVEN TEMPERATURE:

FINISH TIME:

9:15

10 14-10-28

DAS 34 9-89

150

150

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10 x 11/10/28

DAS 15 9-89

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Item ID: D2362-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Support Bracket
 Start Date: 10/20/14 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/24/14 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Small Fab	Small Fab	0.00				10x			14/10/27
Small Fab	Memo	0.00							
Small Fab	Bond rubber D2397-1 followed by D2397-3 using contact cement as per Dwg D2362 Batch <u>M128571</u>								
170 *170* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							14.10.28
180 *180* Packaging	Identify as per dwg & Stock Location: <u>8537</u>	0.00							
Packaging	Memo	0.00				10x			

DAS
36
9-89

DAS
26
9-89

OCT 28 2014

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Item ID: D2362-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Support Bracket

Start Date: 10/20/14 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/24/14 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 14-10-28
MF
14-10-28

Picklist Print

October-20-14 8:01:43 AM

Page 1

Work Order ID: 125664

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Parent Item: D2362-3

D2362-3

Parent Item Name: Step Support Bracket

Start Date: 10/20/14

Required Date: 10/24/14

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: G00.05.18Added inspection level 8EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2265		Manufactured	No			160	Each	78.0000	1	6			
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D2265

Step Bracket

Location	Loc Qty	Loc Code
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ST361	40	
122090	40	
ST488	38	
103258	18	
97950	20	

D2397-1		Manufactured	No			160	Each	13.0000	1	6			
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D2397-1

Rubber Cushion

Location	Loc Qty	Loc Code
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GA	13	
125044	13	

D2397-3		Manufactured	No			100	Each	13.0000	1	6			
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D2397-3

Rubber Cushion

Location	Loc Qty	Loc Code
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GA	13	
125045	13	

and 14/10/25

14/10/27 **DAS 36 9-89**

14/10/27 **DAS 36 9-89**

10

10

10

DART AEROSPACE LTD		Work Order:	1756day
Description: Step Support Bracket		Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	0.258	/		Vern	ML-06
3.074	+/-0.010	3.074	/			
0.34	+/-0.030	0.334	/			
0.77	+/-0.030	0.794	/			
1.500	+/-0.010	1.500	/			
1.000	+/-0.010	1.000	/			
0.80	+/-0.030	0.775	/			
1.200	+/-0.010	1.200	/			
1.28	+/-0.030	1.270	/			
1.000	+/-0.010	1.000	/			
0.75	+/-0.030	0.753	/			
1.88	+/-0.030	1.870	/			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	14/10/26	Date:	14-10-27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>



RELEASED
96.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED KE	APPROVED CP	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04	TITLE STEP SUPPORT BRACKET	SCALE 1:2	
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

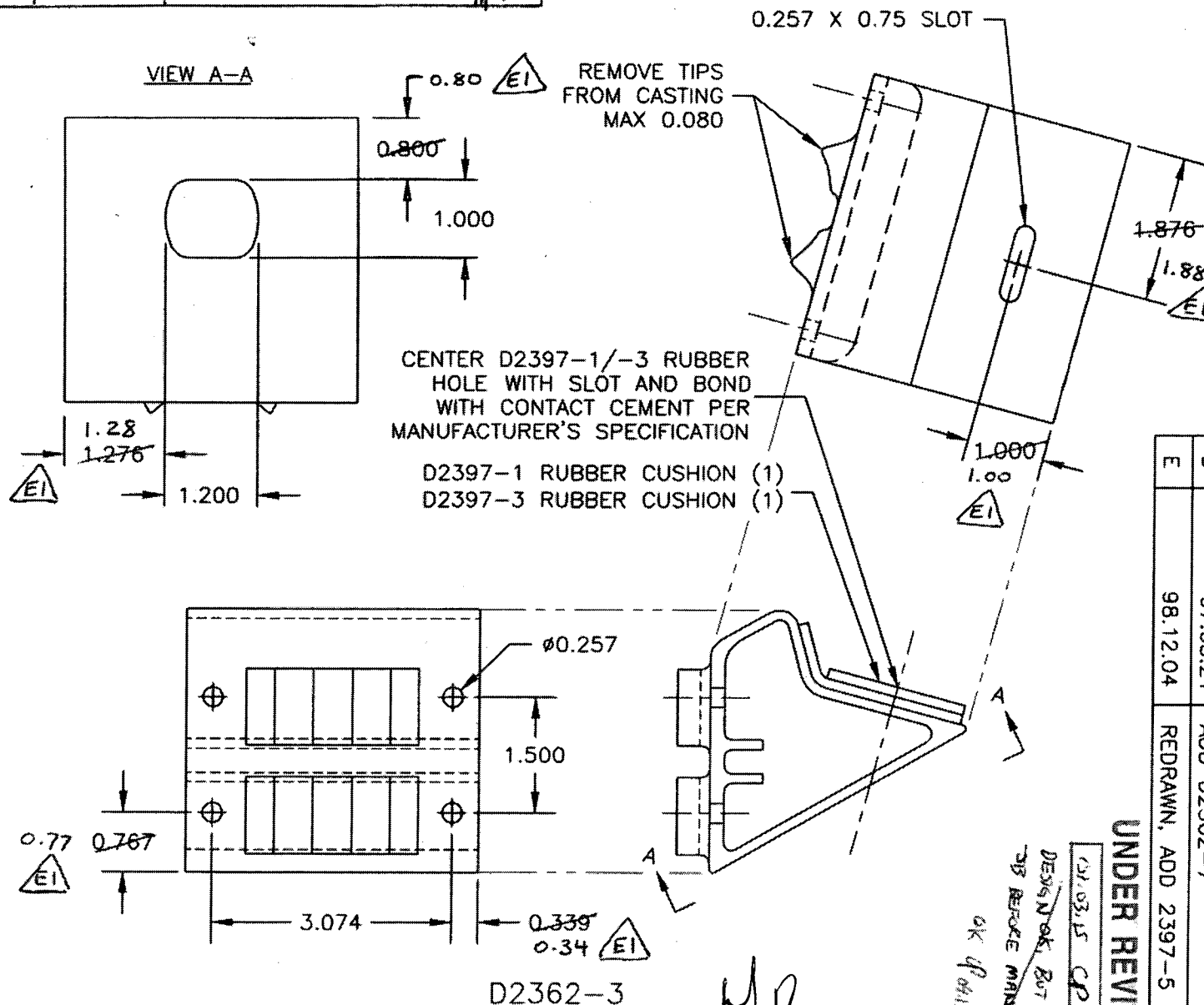
UNDER REVIEW

98.03.15 CP

DESIGN OK BUT CHECK WITH
JIB BEFORE MANUFACTURE
OK 4/2/11/04

40
125664

EI 03.10.07 TOLERANCE CHANGE ~~RT~~



NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED